

## Technical Data Sheet BrazeTec r 1 Paste

### Standard

DIN EN 1045  
AWS A5.31-92R

FH10

### Based on

boron compounds, fluorides

### Technical Data

Working temperature range  
Colour  
Density  
Flux residues  
Shelf life

approx. 520 - 630°C  
colorless  
approx. 1.2 g/cm<sup>3</sup> (20°C)  
corrosive, water-soluble  
min. 6 months, but only in the original sealed container at  
storage temperatures between +5 to +30°C.  
Avoid rapid changes in temperature.  
Stir well before use.

### Packaging

Standard

5.0, 10 kg

### Applications

BrazeTec r1 is a flux for brazing copper and conditionally copper alloys.  
BrazeTec r1 is suitable for all flame brazing, for induction brazing and resistance brazing procedures.  
Typical applications are found e.g. in the spectacle industry.  
Flux BrazeTec r1 is a low melting flux with short life time. Therefore, it is especially suitable for short brazing times (< 10 sec).

### Further Information

Additions of water may negatively alter these parameters.  
Flux residues are corrosive and have to be removed by washing or by pickling.

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